

Date: Monday, 15/06/2009 4:20:15 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HAT BIN 206 A/B W/LITTER, IVORY
Job Number : 48593A	
Estimate Number : 13690	
P.O. Number :	Part Number : D38243KIV
This Issue : 15/06/2009 S.O. No. :	Drawing Number : D3824-3
Prsht Rev. : NC	Project Number :
First Issue : // Type : THERMOFORMING	Drawing Revision : 8
Previous Run : 46919	Material : MKYD6185S125P362015
Written By :	Due Date : 22/06/2009 Qty : 2 Um: 8 Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est. Rev. A 08/123/08 New Issue DL Rev. B Dwg. Update 09/02/09 DL verified by:DD Est. Rev. C Add Colour Code 09/06/02	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S125P362015	6185 KYDEX .125"
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Comment: Qty.: 11.4442 sf(s)/Unit Total : 34.3325 sf(s)
 6185 Kydex .125" Ivory

M110426

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

Sh 09/06/17.

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

Sh 09/06/18.

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3824-3 and folio FTA 034 using tool DT 9448

Dwg. Rev. CFolio Rev. B

Sh 09/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/06/2009 4:20:15 PM
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5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

DL 09/06/18.

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JB 09/06/18 (x2)

7.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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(x2)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

DL 09/06/18

8.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(x2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DL 09/06/18.

9.0	QC5	INSPECT WORK TO CURRENT STEP
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IVORY

Comment: INSPECT WORK TO CURRENT STEP

S 02/06/23 (x2)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Held in Thermoforming -
Held for Packaging.

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



MF 09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48593A
Description: Flat Bin 206 A/B w/ Litter Tray	Part Number:	D3824-3K1V
Inspection Dwg: D3824 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wh- Date: 09/06/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.43 "	± 0.05 "	0.427	✓			
48.5"	REF	48.4	✓			
34.1"	REF	33.78	✓			
41.6"	REF	41.5	✓			
3.5"	REF	3.375	✓			
0.055"	MIN	0.110"	✓			

Measured by: Wh- Date: 09/06/18

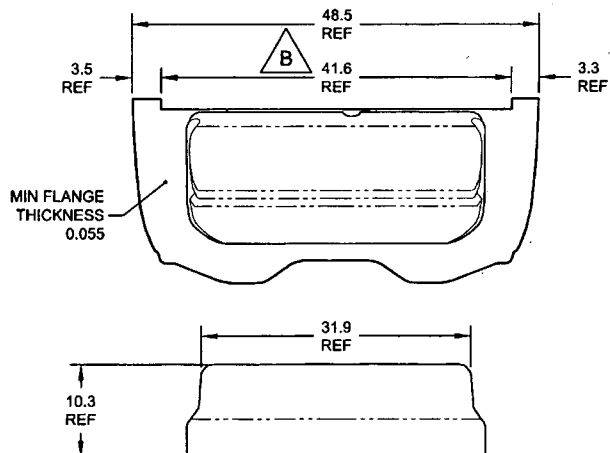
Audited by: S Date: 07/06/13

Prototype Approval: N/A Date: N/A

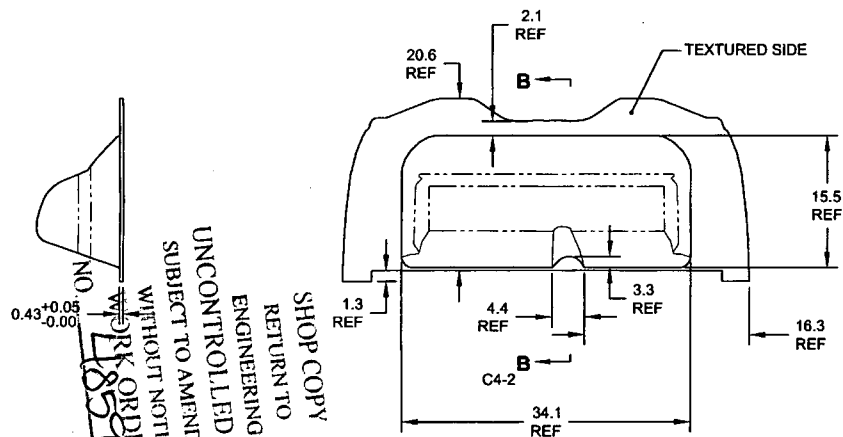
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Handwritten signature]

8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X



D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3824-3KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-3KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3824 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		HAT BIN (BELL 206 A/B) NTS
DATE	09.05.05	

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RELEASED
7/25/12

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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